

Work Order ID 54815 - 2

December 22, 2009 1:26:55 PM

*Split*



Page 2

Item ID:	D3709-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Angle					
Start Date:	1/05/10	Start Qty:	6.00		Cust Item ID:	
Required Date:	1/15/10	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Form as per dwg D3709								
140  QC	QC5- Inspect part completeness to step-on W/O	0.00							
Quality Control	Memo	0.00							
150  HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							

*SB 10/03/09 (6) 4 Pto →*

*Subslio*

*(6) 4*

*HD 10/03/10*

*(6) 0*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3709-3 PAR #: \_\_\_\_\_ Fault Category: Small Def NCR: Yes No DQA: \_\_\_\_\_ Date: 10/03/09  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 10/03/11

NCR: <u>54815-2</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/03/09</u>	<u>130</u>	<u>1 part crack at</u> <u>when was form</u> <u>P.C process</u>	<u>[Signature]</u>	<u>Scrap &amp; destroy</u> <u>NO-Replace</u>	<u>SB</u> <u>10/03/09</u>	<u>[Signature]</u> <u>10/03/10</u>	<u>[Signature]</u>	<u>10/03/09</u>

NOTE: Date & initial all entries

Split

# Work Order ID 54815-2

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Page 1

Item ID: D3709-3

Accept



Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 1/05/10

Start Qty: 6.00



Cust Item ID:

Required Date: 1/15/10

Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: C2

Date: 09/12/23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3709

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3709 Dwg Rev: A Prog Rev: A

☐

\*\*\*\*grain direction on a 45 degree \*\*\*\*

☐ 2- Debur if

necessary

B 10-1-7

10

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-1-17

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

=> 8/10/10/10

10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 54815

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Page 3

Item ID: D3709-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 1/05/10

Start Qty: 6.00



Cust Item ID:

Required Date: 1/15/10

Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

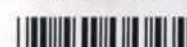
QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00

BR 10-3-10

6

0



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 83

0.00



Packaging

Memo

0.00

Packaging

Rep/11 6

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/11

WMC

10-3-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 54815



Parent Item: D3709-3



Parent Item Name: Angle

Start Date: 1/05/10

Required Date: 1/15/10

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

sf

55.7377

1.6800

3.



B 10-1-7

6061-T6 .063 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

55.73772105

110551

29.6341211

112939

26.1036

112939

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

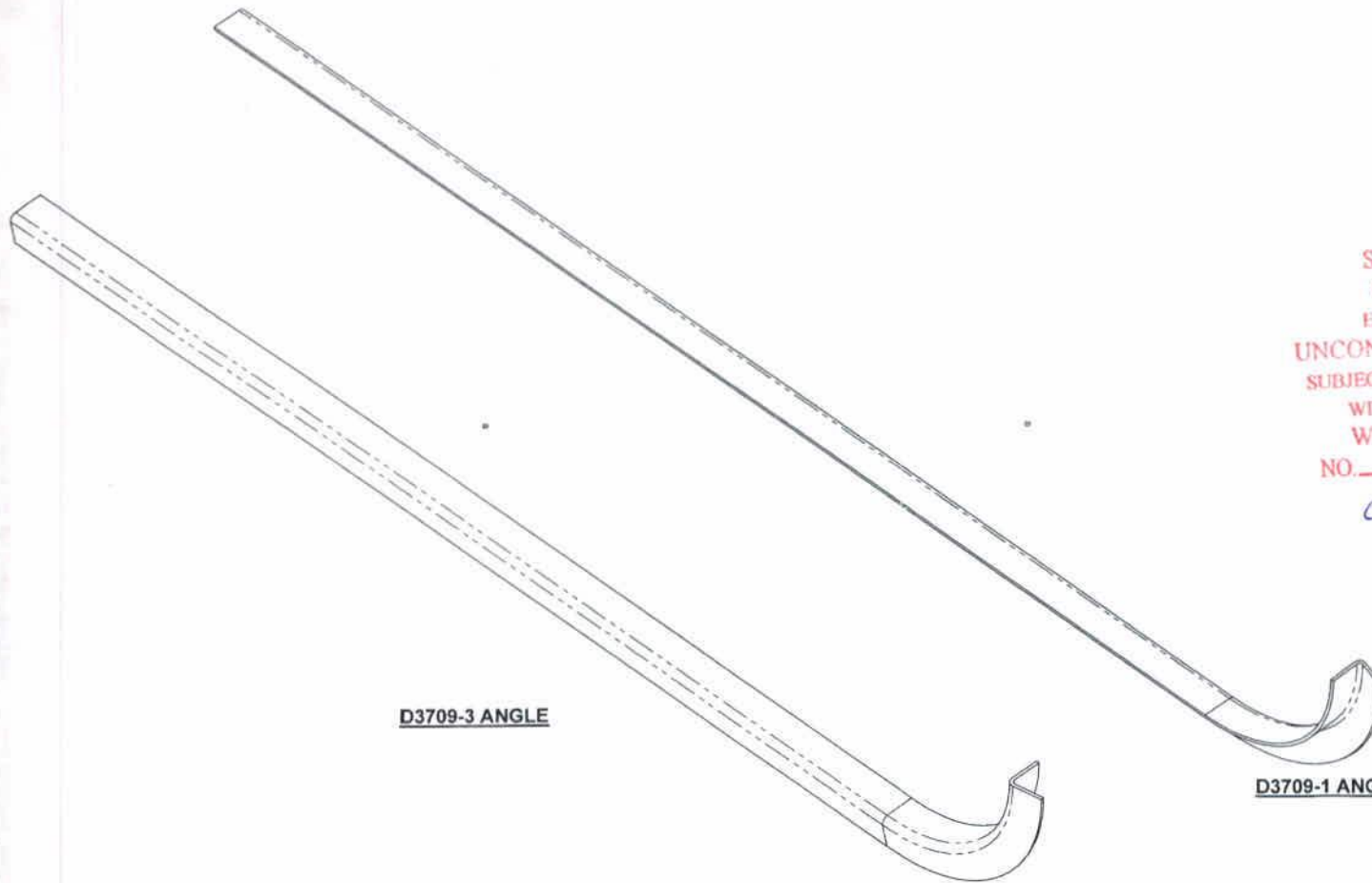
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries







**D3709-3 ANGLE**

**D3709-1 ANGLE**

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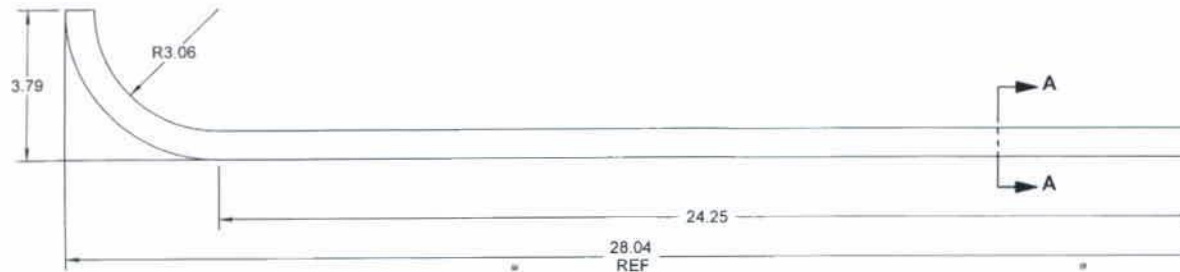
*C209112123*

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*09/04/1978*

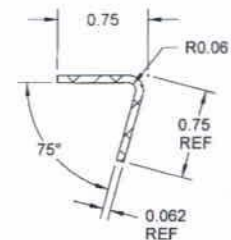
**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3709-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3709-1 = 0.24 lbs  
D3709-3 = 0.16 lbs

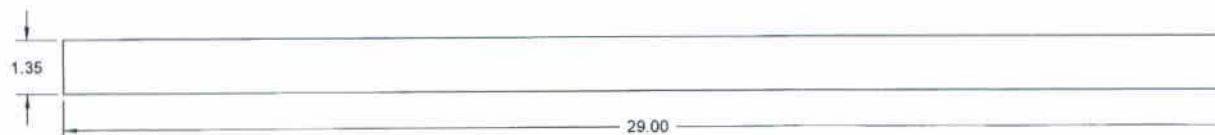
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APPROVED			
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**D3709-1 ANGLE**  
(MAKE FROM D3709-1F)



**SECTION A-A**  
SCALE 2X

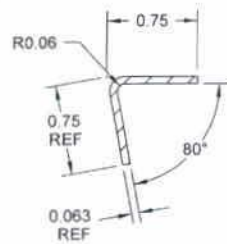


**D3709-1F ANGLE FLAT PATTERN**

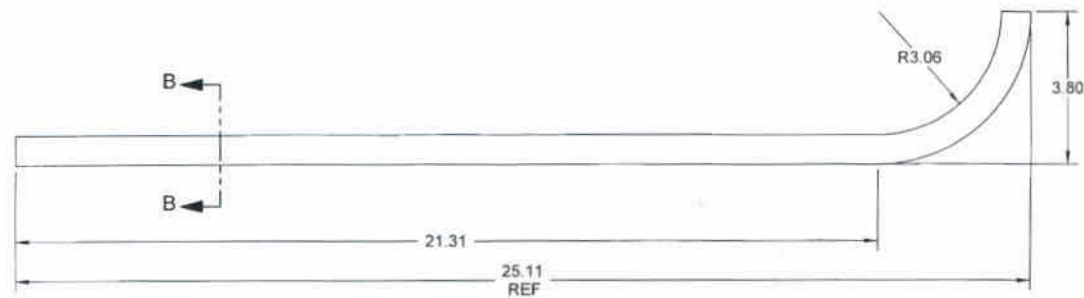
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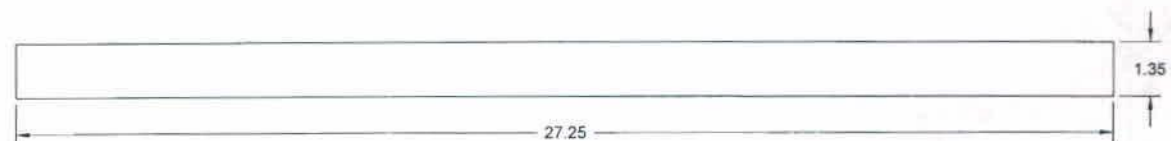


**SECTION B-B**  
SCALE 2X



**D3709-3 ANGLE**  
(MAKE FROM D3709-3F)

GRAIN  
DIRECTION



**D3709-3F ANGLE FLAT PATTERN**

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